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order 9274
Dec 10

C10-27

Job Sheet 185296



Part No: C10-27

Job Qty: 1 ea

Part Name: Cage Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C10-27 Rev 9 IPP REV A RQ 17.09.05 VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/16/18	0.00	0.00	Start Up Large Fab-1		EL
100	Large Fab	1 pcs		11/16/18	0.00	0.00	Large Fab 3		EL
120	QC	1 pcs		11/16/18	0.00	0.00	QC9		BF
140	Powdercoat	1 pcs		11/16/18	0.00	0.00	Powdercoat6		BL 18-12-5
160	QC	1 pcs		11/16/18	0.00	0.00	QC3		S
180	Packaging	1 pcs		11/16/18	0.00	0.00	Packaging3-1		S
200	QC21-SA	1 Ea		11/16/18	0.00	0.00	QC21		DAS

Part Op 100 - US WELD FIXTURE C-10

Descriptions: 140 - START TIME: 1:05 OVEN TEMPERATURE: 320° FINISH TIME: 1:35 21 9-89

M 129222

DEC 06 2018

Job BOM

226872

Part / Item	Component Name	Quantity	Operation	Container
C10-27-1	Lifting Plate	2 Ea (2 ea)	90-Start up Operation	5073461
C10-27-10	Side Loop Wrap Around	2 Ea (2 ea)	90-Start up Operation	5102110
C10-27-2	Cage Reinforcement	2 Ea (2 ea)	90-Start up Operation	5077993
C10-27-3	Front Guard Plate	1 Ea (1 ea)	90-Start up Operation	5084785
C10-27-4-1	Top Ring	2 Ea (2 ea)	90-Start up Operation	5101905
C10-27-8	Bumper Plate	1 Ea (1 ea)	90-Start up Operation	5084135
C10-27-9	Space Bar Wrap Around	2 Ea (2 ea)	90-Start up Operation	5102186

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	C10-27-1	2	6	0
 Container No: S134805 Part: C10-27 Job No: 185296 Serial No/Batch: S134805 Revision: 9 Inspector: Exp Date: Instructions:			6	0
			6	0
			4	0
			10	0
			6	0
			10	0
			6	0

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lex 10/24/18 2:10 PM Dart.lajeunesse.marie

Date: 12/05/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

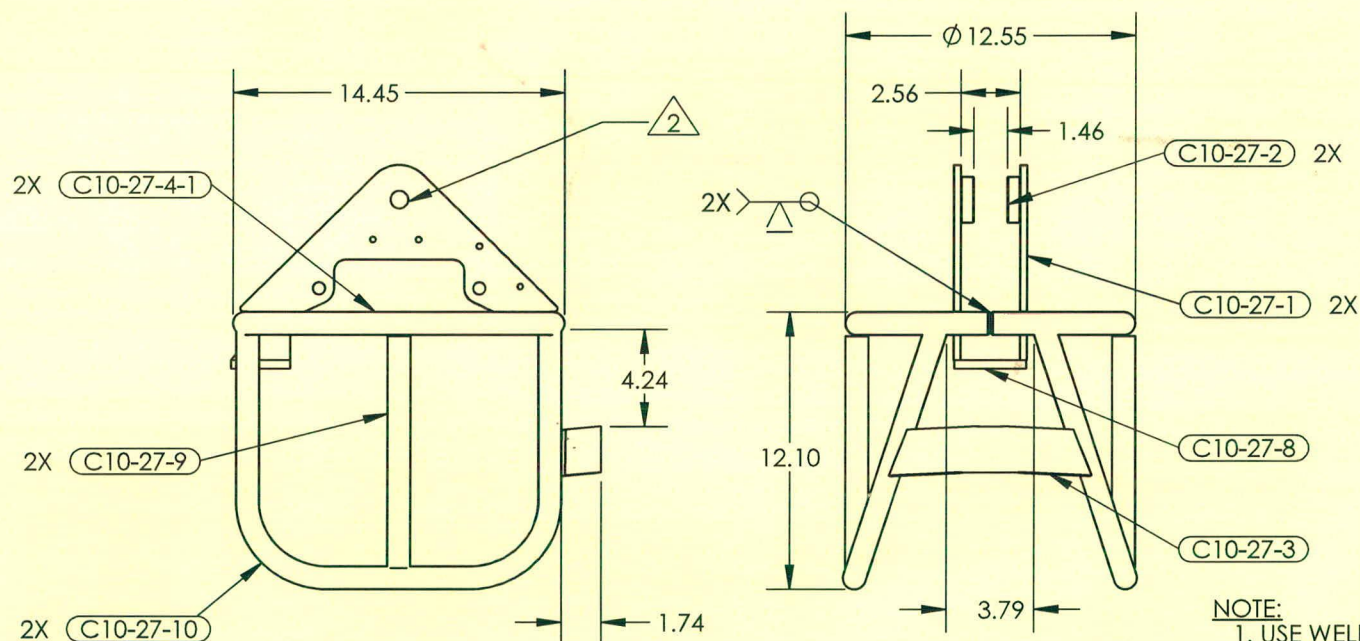
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6		AS DRAWN BY APICAL	1/9/2013	JAG	
7		CH'D 1.27 DIMENSION TO 1.75 TO MATCH PARTS	1/9/2013	JAG	
8		-9 CH'D LENGTH WAS 10 IS 10-1/8. -10 ADDED COPING 2X R .5 X .25 DEEP.	2/27/2013	BIM	JAG
9	16-0169	-9 DELETED FINISH SPEC WAS RAL 3000 IS NO SPEC, CH'D NOTE 1 ADDED C10, ADDED NOTE 2 CH'D DWG TO SHEET METAL TOLERANCE.	10/13/2016	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185296 MJS
1870-24

NOTE:
1. USE WELD FIXTURE C-10, WELD ALL CONNECTIONS 100%.

2. HOLES MUST ALIGN.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description
			C10-27-1	2	LIFTING PLATE
			C10-27-2	2	CAGE REINFORCEMENT
			C10-27-3	1	FRONT GUARD PLATE
			C10-27-4-1	2	TOP RING
			C10-27-8	1	BUMPER PLATE
			C10-27-9	2	SPACE BAR WRAP AROUND
			C10-27-10	2	SIDE LOOP WRAP AROUND

DART AEROSPACE	
TITLE CAGE WELDMENT	
DWG NO. C10-27	REV 9
MAT'L HEAT TREAT FINISH POWDER COAT RED SPEC DRAWN BY: APICAL CHECKED: DUERFELDT OPSS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL	
SCALE 1:8	DATE 9/26/2006
SHEET 1 OF 1	

